

Work Order ID 51070

July 30, 2009 10:18:36 AM



Page 1

Item ID: D212-664-107

Accept



Setup Start



Revision ID: A

Stop



Item Name: Crosstube Low Standard Fwd

Start Date: 08/03/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/21/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: MP Date: 09-07-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-147	Rev A								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D212-664-107 CHG001

Scrap

110

0.00



Packaging

Packaging

Memo

0.00

Packaging

120

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D412-664-243 using CNC bender program 412 af and

Relic FT010

212-107

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-664-107 PAR #: N/A Fault Category: cross tube NCR: Yes No DQA: / Date: 09-12-08
 Resolution: SCAP Disposition: SCAP QA: N/C Closed: / Date: 09-12-11

NCR: 51070		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/9/9	120	tube broke while beating Re: Process.	<u>AB</u> 09/12/07 QST042	-cut up tube	<u>AB</u> 09-09-09	<u>S</u> 02/12/07	<u>AB</u> 09/12/07 QST042	<u>S</u> 02/12/07

NOTE: Date & initial all entries

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Start Date: 08/03/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 08/21/2009 Req'd Qty: 1.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC15- Crosstube Dimensional Check	0.00							
QC Quality Control	Memo	0.00							
140 	Crosstubes	0.00							
Crosstubes Crosstubes	Memo 1-Drill Rivet holes as per Dwg D212-664-147 using DT8972. □2-Drill pilot holes in tube as per Dwg D212-664-147 □3-Ream hole to finish size in tube as per Dwg D212-664-147 □4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-6	0.00							
150 	Crosstubes Chemical Conversion	0.00							
HandFXtube Hand Finishing Crosstubes	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Start Date: 08/03/2009 Start Qty: 1.00



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Required Date: 08/21/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
180 	Outsource process - NDT per QSI038 4.1	0.00							
Outsource2 Outsource process - NDT	Memo Liquid Penetrant Inspection as per QSI 038 Or <input type="checkbox"/> Issue P/O: _____ LPI as per ASTM 1417 <input type="checkbox"/> Level 2 Attach copy of NDT results to work order	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Cust Item ID:

Customer:

Setup Start




Stop

Run Start

Stop

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Ensure copy of NDT results attached to work order.								
200 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Inspect for damage & ensure results are as per Dwg D212-664-203								
210 	Crosstubes	0.00							
Crosstubes	Memo	0.00							
Crosstubes	1-Rivet Cuffs as per Dwg D212-664-147. with Sika flex in Between tube & Cuff □/R SIKAFLEX -241/-291 BATCH: _____								

212-664-107

M

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 08/21/2009 Req'd Qty: 1.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  SprayPaint Spray Painting	Memo 1-Prime inside and outside crosstube as per QSI 005 4.2□2-Paint outside crosstube with White Imron as per QSI 005 4.2 □ PRIME:□Start Time:_____□Fininsh Time:_____□PAINT:□Start Time:_____□Finish Time:_____	0.00 0.00							
230  QC Quality Control	QC14- Inspect Spray Paint Memo Wrap in plastic bag to protect from scratches	0.00 0.00							
240  Crosstubes Crosstubes	Crosstubes Memo 1- Assemble as per Dwg D212-664-147□2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe□3- Instal support with magnobond 6398 per dwg D212-664-147,□cure for 12hrs before packaging.□Time & date of applic	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 08/21/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
260 	QC4- 100% Inspect kits for completeness	0.00							
QC Quality Control	Memo	0.00							
270 	Packaging	0.00							
Packaging Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D212.664-107								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Cust Item ID:

Required Date: 08/21/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
290 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

u 8.12.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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July 30, 2009 10:18:36 AM

Work Order ID: 51070

Parent Item: D212-664-107RevA

Parent Item Name: Crosstube Low Standard Fwd



Comments:

Start Date: 08/03/2009

Required Date: 08/21/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3428-1RevA		Manufactured	No			100	Each	56.0000	1.0000			
												
Placard												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	16	
47310	6	
48359	10	
Main Warehouse		
ST096	40	
50790	40	

D212-664-
107TRNRevA

Manufactured No

140

Each

0.0000

1.0000



Crosstube Turning Detail

D3659-1RevB

Manufactured No

220

Each

8.0000

2.0000



CUFF

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
37426	8	

B-50701 MB 09-09-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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July 30, 2009 10:18:36 AM

Work Order ID: 51070



Parent Item: D212-664-107RevA



Parent Item Name: Crosstube Low Standard Fwd

Start Date: 08/03/2009

Required Date: 08/21/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

CR3212-4-06		Purchased	No			240	Each	346.0000	44.0000			
-------------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--



CHERRY RIVET

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	346	
----	-----	--

107534	346	
--------	-----	--

D2893-1RevB

Manufactured No

240	Each	72.0000	2.0000
-----	------	---------	--------



2.75 Support

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	72	
----	----	--

25657	6	
-------	---	--

43479	10	
-------	----	--

46488	18	
-------	----	--

47109	18	
-------	----	--

47637	20	
-------	----	--

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 51070



Parent Item: D212-664-107RevA



Parent Item Name: Crosstube Low Standard Fwd

Start Date: 08/03/2009

Required Date: 08/21/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3595-063-450RevA		Manufactured	No			240	Each	47.8000	4.0000			
RUBBER CUSHION												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 47.8

38959 2

43210 4.8

46465 41

AN6-35A

Purchased

No

260

Each

134.0000

4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 134

111605 34

112314 100

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Parent Item: D212-664-107RevA



Parent Item Name: Crosstube Low Standard Fwd

Start Date: 08/03/2009

Required Date: 08/21/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6-36A		Purchased	No			260	Each	169.0000	4.0000			

Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	169	
109632	1	
110382	18	
111650	50	
112314	100	

AN960JD616

Purchased

No

260

Each

1,326.000

18.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1326	
107242	3	
107959	6	
109371	8	
110704	23	
111193	18	
111607	268	
112314	1000	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Crosstube Low Standard Fwd


Comments:

Start Date: 08/03/2009

Required Date: 08/21/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L6 		Purchased	No			260	Each	755.0000	6.0000			
Nut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	755	
105077	22	
110002	233	
111548	100	
111578	400	

MS21920-25



Clamp(per MIL-DTL-8783C)

Purchased

No

260

Each

156.0000

4.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	156	
107456	2	
108111	3	
108975	17	
109181	48	
109644	10	
111282	50	
111429	25	
111883	1	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

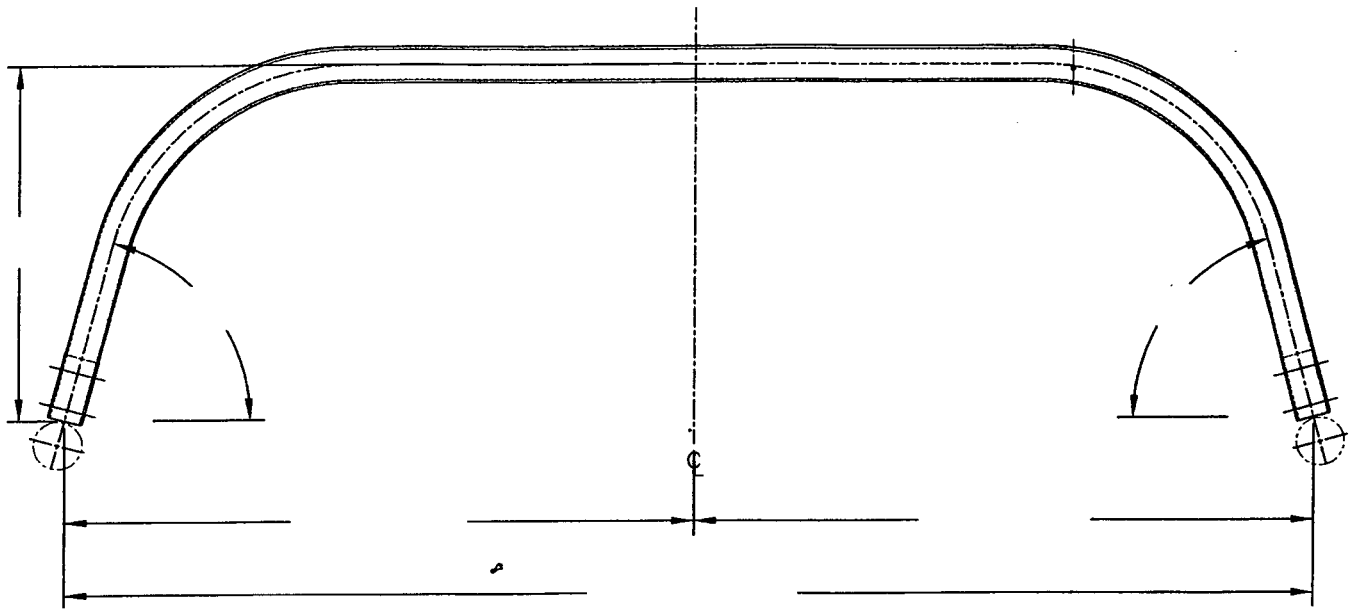
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 51070
Description: Crosstube Low Fwd (205/212/412)		Part Number: D212-664-107
Inspection Dwg: D212-664-147 Rev: A		Page 1 of 1

Required Dimension	Min	Max
Height	20.79	21.05
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/JM	

51070
214F
09-09-30

PARTS LIST:

Qty	Part Number	Description
X	D212-664-147	CROSSTUBE ASSEMBLY (205/212/412 LOW FWD)
1	D6019-128	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
2	D3659-1	CUFF
4	MS21920-25	CLAMP (OR MS21920-26)
44	CR3212-4-06	RIVET (OR M7885/3-4-06)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-2411-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

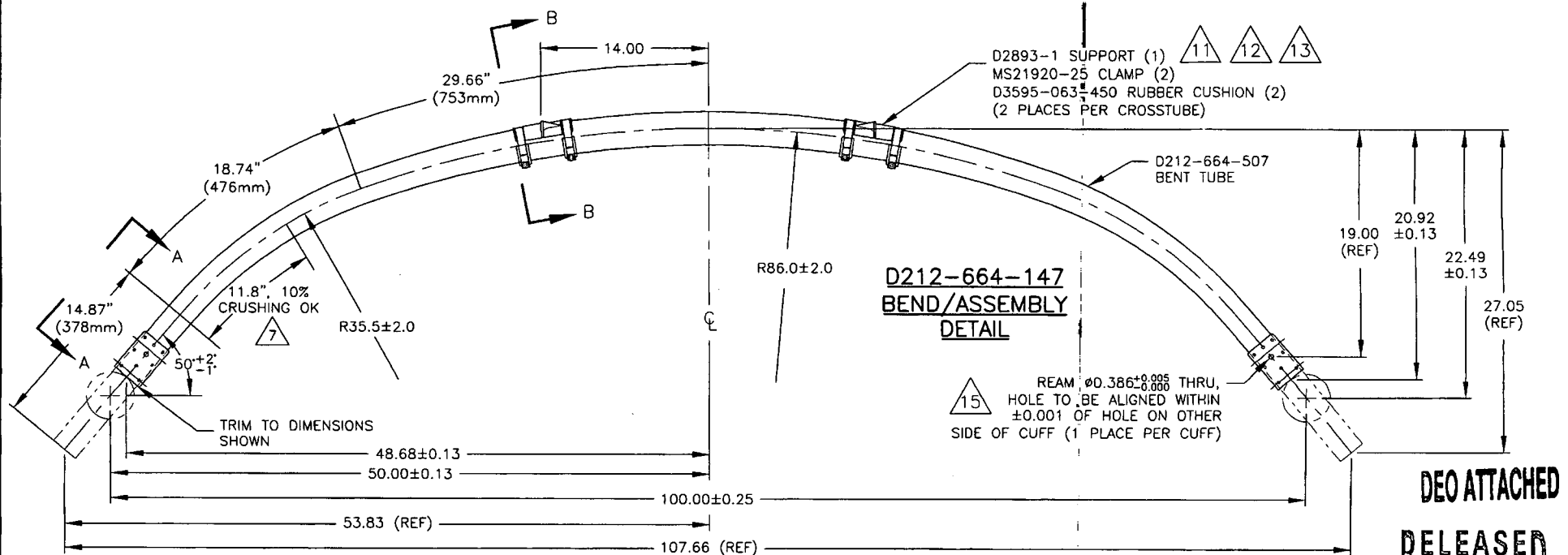
GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6019-128
FINISHED LENGTH = 126.53±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE.
- 6) WHEN MACHINING TAPER, RUN-OFF PART AT STOCK. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 7) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 8) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 9) SCRIBE DART PART NUMBER AND BATCH NUMBER ON INNER SURFACE OF TUBE WITH A
VIBRATING STYLUS.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1
THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE
D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE
CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY
AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INSTALL D3659-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A
LAYER OF SIKAFLEX-2411-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN
CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

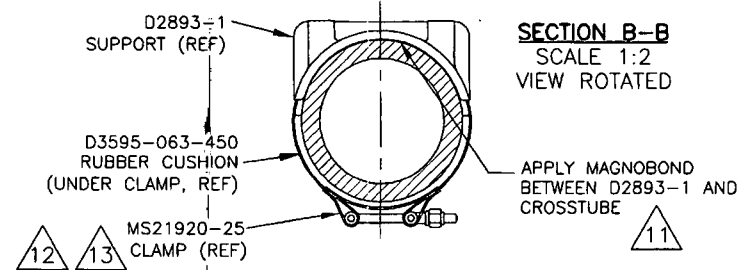
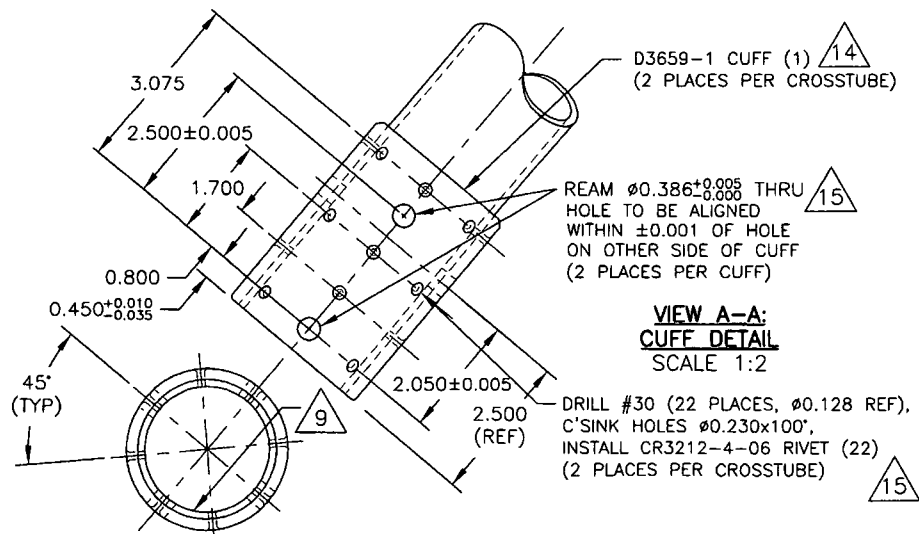
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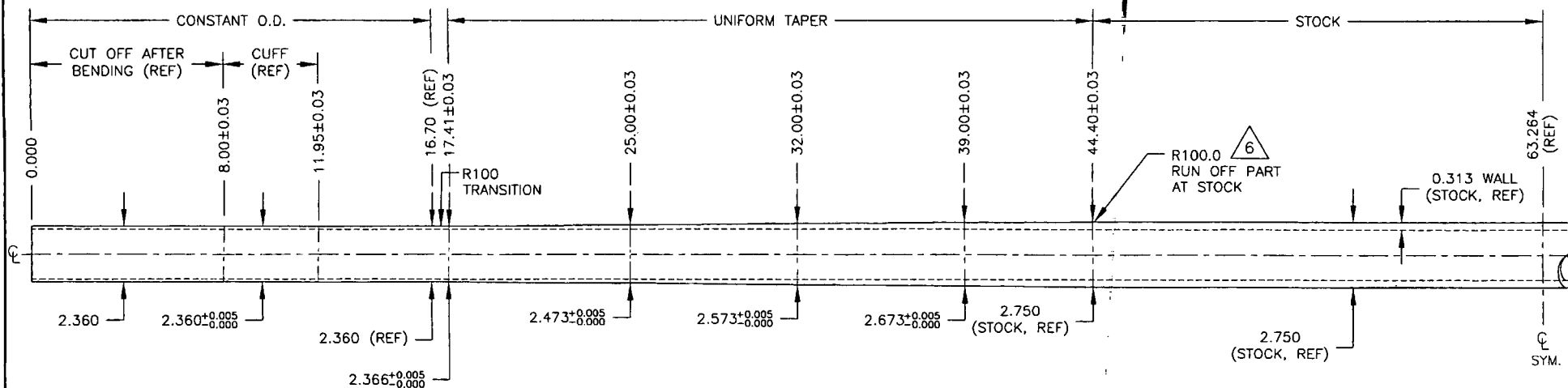
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		CROSSTUBE (205/212/412 LOW FWD) NTS		SCALE



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				REV. A	SHEET 2 OF 3
				SCALE	1:8



D212-664-147 MACHINING DETAIL

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DATE 07.07.07		TITLE CROSSTUBE (205/212/412 LOW FWD)		SCALE 1:4	

DRAWING NO. D212-664-147	TITLE CROSSTUBE	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-147-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CD</i>	CHECKED <i>PH</i>	MFG. APPR. <i>E</i>	APPROVED <i>MD</i>		DE APPR. <i>PH</i>		
DATE 09.05.01	DATE 09.06.15	DATE 09.06.15	DATE 09/06/15		DATE 09/06/16		

CHANGE:

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

Part Number	Description
D212-664-147B	CROSSTUBE ASSEMBLY (214 LOW FWD)

THE D212-664-147B CROSSTUBE HAS THE SAME PARTS LIST AS THE D212-664-147 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D212-664-147 CROSSTUBE.

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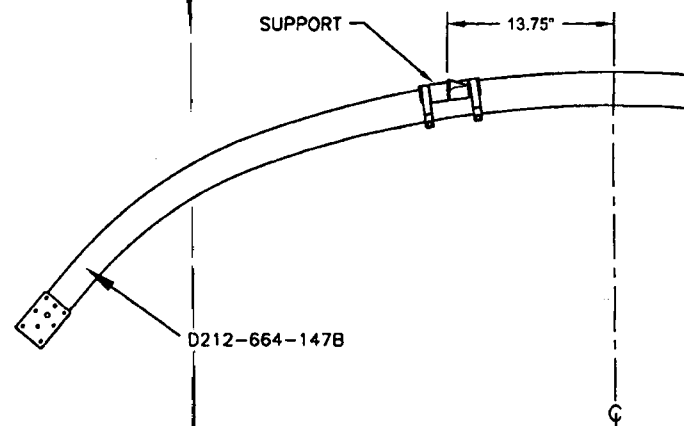


FIGURE 1- SUPPORT INSTALLATION

PERSON THAT IT IS
PERSON WITHOUT